Work Orde September-23-13	r ID 107161 11:10:10 AM			*107	161*							Page 1	
Revision ID:	D2364 Deck Plate Fwd		A	Accept	*N90	0040	1100)*	Setup S	tart top	I VI	S1* S2*	
,	9/23/13 Start Qty		*6* *6*		Cust Iter Custome						I W		
Approvals:	Process Plan:M QC:		Date: 13-09-24	Tooling: SPC (Y/N):		Date:		1		tart stop	*N *N	R1* R2*	
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool II) Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr												
D2364	Rev F												-
*100 *100* Waterjet FLOW CNC Waterje 2024 .063		Memo	Dwg D2364 Dwg Rev:_ cessary	0.00	2-			_ 7	٥			JmB-11	- ق- ہ
110	QC2- Inspec	ct parts off ma	achine FAI/FAIB	0.00									٠
110 QC Quality Control		Мето		0.00				7	0			Jm13-1	10.2
120	QC8- Inspe	ct parts - seco	nd check	0.00 DAS 27				7					
120 QC Quality Control		Memo		0.00 B 10 6	S								

NCD.	Voc	1	No
NCR:	Yes	/	NO

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
•		

								-		QA Closed:	Dat	te:
Work Order:					DISPOSITION			,	AGAINST DE	PARTMENT	/PROCESS	
Part No.	į				Rework Scrap Use-as-is Work Order Update		l herm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality
Root				Descri	ption of work order update	Init	ial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
<u> </u>						AULT (CATE	GORY	<u> </u>			
Landing	Bending Centre No Cracks Crushed/ Cuffs Heat Treat Inspectio Ripples in	Crimped at on Strip in n Bend Vaves in E	Tube Extrusion		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Ha In:	struct lainte islabe isread ffset ut of 0	ion Incomplete ions Incomplete, enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Mayo/Tu				Teolio		utcido	Dimensions				

Work Orde				*107	'161*	,		-		Page 2
Item ID: Revision ID: Item Name:	D2364 Deck Plate	Fwd		Accept	*N9000	4010	n* s	Setup St	iV	S1* S2*
Start Date: Required Date: Reference:	9/23/13 9/23/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:					:
Approvals:	Process F	Plan:	Date:	_ 0 _	Date:	;	I		art *N op *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID 7	Fool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Small Fab		Small Fab Memo 1 - counter s	ink holes as per dwg D23	0.00 642- deburr if necessary			K			3/10/29
*140 *140* QC Quality Control		QC5- Inspect part comp Memo	leteness to step on W/O	0.00 DAS 27 9-89 0.00 3 10 2	9		7			
150 *150* HandFinish		Chemical Conversion C	oat per QS1005 4.1	0.00			7	H	4311	kJ
Hand Finishing										

DAS 36 9-89

		-									DQA:	Date	!:
NCR: Y	es /	No				WORK ORDER NON-C	ONFO)RN	MANCE / UPDATE		QA Closed:	Date	:
Work Orde	or.					DISPOSITION			AGAINST D	EF	PARTMENT/	PROCESS	
Part N	No					Rework Scrap Use-as-is Work Order Update	Th	۱ erm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root		<u> </u>			Descri	otion of work order update	Initia	al T	Action	\neg	Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	Chief E		Description		Date	Verification	QC Inspector
Doc/Data			'							7			,
Equip/Tooling	П												
Operator													
Material	П				٠								
Setup	П												
Other	П		ļ							١			
Process	П									-			
Supplier													
Training													
Unapproved													
				•		F,	AULT CA	ATEC	GORY				
Landi	ng Gea	ar				General					•	_	_
	∐B€	ending				Bend	Gra	iin	<u></u>		Ovalized		Pressure/Forced
	C€	ntre No	ot Concer	ntric to	o/s	BOM/Route	Har	dwa	re		Over/Under	tolerance	Temperature/Cure
	∐Cr	acks		-		Broken/Damaged	Insp	ecti	on Incomplete		Part Incorred	rt	Weld
	Cr	ushed/	Crimped			Burrs	Inst	ructi	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cı	ıffs				Contamination	Ma	inte	nance		Part Moved	_	
	Пн	eat Trea	it			Countersink	Mis	labe	led	\neg	Positioned W	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Work Ord September-23-1				*	107	161	1*							Page	3
Item ID: Revision ID: Item Name:	D2364 Deck Plate Fv	vd		Accept		*N9	900	040	100)*	Setup	Start Stop	1 71	S1* S2*	
Start Date: Required Date: Reference:	9/23/13 : 9/23/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*				st Item II stomer:	D:							
Approvals:	Process Pla	an:	Date:					te:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center I 160 *160* Powdercoat Powder Coating	D	Operation Description Black Sandtex(Ref.4.3.5) Memo STARTAIN	700	Set U Run 0.00 0.00 0.00 OVENTEMI	Hours	T	ool ID	Tool#	Plan Code	Accept Qty	Rej Qty	y 1	Reject Number	Insp. Stamp	g
170 *170* QC		QC3- Inspect Part Finish	ı	0.00	DAS 27 9-89	O 0				7					_

0.00 13/1/08

Identify as per dwg & Stock Location: 572204 0.00

120 Packaging

Quality Control

Packaging

0.00

7x M.D. 13-11-8

180

Memo

Memo

NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
Closed:	Date:	

									QA Closed:	Date	:
Work Order	:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No)				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	1 /	Action	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chief E	ng De	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling									ļ		
Operator											
Material		ļ									
Setup	_										
Other											
Process	4										
Supplier	_										
Training	-										
Unapproved								 	<u> </u>		
				· · · · · · · · · · · · · · · · · · ·		AULT CA	TEGORY				
Landin					General		•		ا داد	Г	7
-	Bending			_ <u> </u>	Bend	Gra		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	Centre N Cracks	ot Concer	TITIC TO	U/3 -	BOM/Route Broken/Damaged	${f oxed{H}}$	dware ection Incomplete	<u> </u>	Over/Under Part Incorre	<u> </u>	Temperature/Cure Weld
	Crushed/	Crimpod		-	Burrs	⊢ ⊢	ruction incomplete		Part Lost/Mi		Wrong Stock Pulled
-	Cuffs	Cimped		-	Contamination	⊢	intenance	e/ Officieal	Part Moved	issuig [
-	Heat Trea	at		 -	Countersink	\vdash	labeled	<u> </u>	Positioned V	Vrong	
 -	Inspection		Tube	-	Cut Too Short	Mist		 	Power Loss/	_	Other
<u> </u>	Ripples in	•	Tube	<u> </u>	Drill Holes	Offs		L	J. 5WC: 2033/		Totalet
<u> </u>	— ' '	Vaves in E	Extrusio	, <u> </u>	Drawing	\mathbf{H}	of Calibration				
		Sequence			Finish	⊢	of Sequence				
		vist in Tul		-	Folio	\vdash	side Dimensions				· · · · · · · · · · · · · · · · · · ·

Work Order ID 107161 *107161* Page 4 September-23-13 11:10:10 AM Accept Item ID: D2364 *N900040100* Setup Start **Revision ID:** Stop Deck Plate Fwd Item Name: *6* Start Qty: 6.00 **Start Date:** 9/23/13 **Cust Item ID: Req'd Oty:** 6.00 Required Date: 9/23/13 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Approvals: Date: Stop Date: SPC (Y/N): QC: Date: Tool ID Tool # Plan Sequence ID/ Operation Set Up/ Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 190 QC21- Final Inspection - Work Order Release 0.00 *100* 0.00 Memo

Quality Control

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFORM	MANCE / UP	DATE	QA Closed:	Date:	
				· · · · · · · · · · · · · · · · · · ·	DISPOSITION			AGAINST DE	· · · · · · · · · · · · · · · · · · ·		·
Work Orde	r:							_		·	,
Part N	lo.				Rework Scrap	i I	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
	:				Use-as-is		noforming	Finishing		re/Packaging	Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier			1								
Training		İ	1								
Unapproved	,									<u> </u>	
	·			·· · · · · · · · · · · · · · · · · · ·	F	AULT CATE	GORY				
Landir	ng Gear				General				3	-	1
	Bendin	g			Bend	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspecti	ion Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped			Burrs	Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Tr	eat			Countersink	Mislabe	eled		Positioned \	Wrong	_
	Inspect	ion Strip in	n Tube		Cut Too Short	Misread	d		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Order ID:

107161

Parent Item:

D2364

Parent Item Name:

Deck Plate Fwd

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV. E00.06.26Removed P/O for powder coatEC IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status I
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	396.1789	0.6469	4.0856844 5.0			Jm13-10.2
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT022		396.1789							
				119	916	0.2							
				121	197	21.34					_		
				123	1096	11.4							
				123	6654	11.64							
				123	3701	31.7039							
				125	341	89.44							
				125	6636	230.455			125	<u> </u>			

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Water Jet Engineering Crosstube Rework Machining Small Fab Prod. Eng. Coor. Quality Part No. Scrap Use-as-is Thermoforming Finishing Rec/Store/Packaging Other NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Action Sign & Initial Root Qty or Non-conformance Chief Eng Description Verification QC Inspector Date Step Date Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

	•		FAU	LT CATEGORY			
Landing	Gear	General					
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Г	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved	-
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		-	
	Torque Waves in Extrusion	Drawing		Out of Calibration		•	
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

DART AEROSPACE LTD	Work Order:	107161
Description: Litter Deck Plate Kit (350)	Part Number:	D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	T-1	Actual	Accept	Reject	Method of Inspection	Comments	
Dimension	Tolerance	Dimension					
6.624	+/-0.010	6.630"			٧	Jamoi	
Ø0.171	+0.005/-0.000	0.173"	_		~		
0.354	+/-0.010	0.362	_		V		
11.242	+/-0.010	11.247"	ا		ν	Produjar	
3.031	+/-0.010	8.3 - 3035			7		
1.903	+/-0.010	1.904"	1)		ν		
1.128	+/-0.010	1.904"	1		ν		
0.354	+/-0.010	0.357"			V		
1.340	+/-0.005	1.344"	~		V		
2.326	+/-0.010	2.321"	_		V		
3.312	+/-0.010	3.309"	-		V		
4.298	+/-0.010	4.296"			V		
5.284	+/-0.010	5.286	_		V		
6.151	+/-0.010	6.153	-		V		
6.270	+/-0.010	6.271"	_		V		
0.354	+/-0.010	0.355"	_		V		
3.031	+/-0.010	3.030			V		
Ø0.656	+0.005/-0.000	0.656"	_		V		
5.003	+/-0.010	5.003"	_		V		
4.605	+/-0.010	4.609"			V		
1.776	+/-0.010	1. 779"	_		V		
0.980	+/-0.010	0.986"	-		V		
4.487	+/-0.010	4.490"			V		
7.192	+/-0.010	7.194"	_		V.		
7.567	+/-0.010	7.566"	_		✓		
7.942	+/-0.010	7.942	-		V		
Ø0.191	+0.005/-0.000	0.193"			V		
Ø0.197	+0.005/-0.000	0.197"	_		V		
11.145	+/-0.010	11.145"	_		V		
12.181	+/-0.010	13.181"	_		T .	Jamo6	
11.378	+/-0.010	11.375	-		V		
11.776	+/-0.010	11.778"	-		V		
12.173	+/-0.010	12.133			7		
4.690	+/-0.010	4.691			ν		
0.250	+0.005/-0.000	0.253"	_		V		
3.141	+/-0.010	3.141"			V		
Ø 0.171	+0.005/-0.000		DAS				

Measured by:	Audited by: 9-89	Prototype Approval:	N/A
Date: 13-10-28	Date: 13 10 28	Date:	N/A

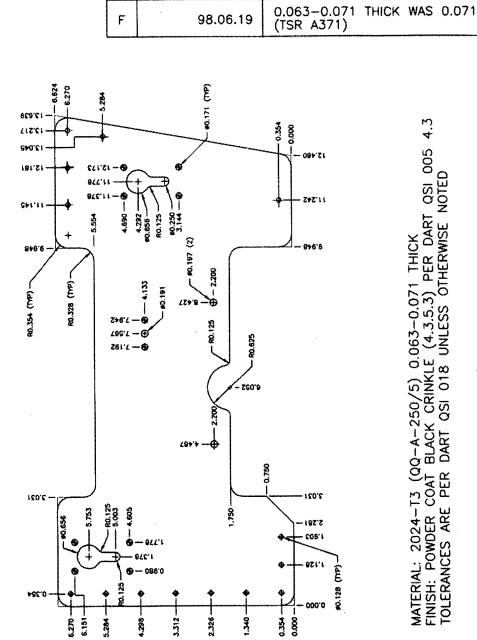
Γ	Rev	Date	Change		Revised by	Approved
r	Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM , ,	
	В	08.05.28	7.567 dimension	n revised	KJ/DD A	





DESIG	YE.	DRAWN BY	DART AEROSPACE L HAWKESBURY, ONTARIO, CANADA	TD
CHEC	(ED)	APPROVED	DRAWING NO.	REV. F
)	W	A	D2364 s	SHEET 1 OF 1
DATE			TITLE	SCALE
98.0	6.19		LITTER DECK PLATE, 350	2:5
 Α		95.01.14	NEW ISSUE	
В		95.02.09	MOVED KEYWAY	
D		95.03.06	0.191 WAS 0.197	
E		95.10.06	GEOMETRY CHANGES	

ERROR
S
CORRECT
ዩ
COUNTER SINK HOLES: COUNTER SINK \$0.225 x 100" (UPDATED FROM 9 TO 14 HOLES BY 05 99.03.01 TO CORRECT CAD ERROR) C'SINK \$0.308 x 100"
\$
<u>ئ</u> ھ
Hores
ī
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4.
Ą
(UPDATED
OLES: 100° (100°
Ξ××
SINK 7.225 7.308
R & &
COUNTER SINK HOLES: C'SINK #0.225 x 100' C'SINK #0.308 x 100'
4.4



MATERIAL: 2024—T3 (QQ—A—250/5) 0.063—0.071 THICK FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED